

# Work Order ID 47718

June 26, 2009 4:20:09 PM



Page 1

Item ID: D3646-1 **BK**

Accept



Setup Start



Revision ID: A

Stop



Item Name: Arm

Start Date: 15/07/2009 Start Qty: 6.00



Cust Item ID:

Required Date: 03/08/2009 Req'd Qty: 6.00

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D3646

Rev A

100

0.00



NC BRAKE

Brake NC

Memo

0.00

Brake NC

1-Punch to length as per Dwg D3646 & template DT8958

*m-h* (6x)  
09/07/01

110

0.00



Small Fab

Small Fab

Memo

0.00

Small Fab

1-Deburr

*m-h* (6x)  
09/07/01

120

0.00



QC5- Inspect part completeness to step on W/O

QC

Memo

0.00

Quality Control

*-S* 02/07/01 (46)

# Work Order ID 47718

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Page 2

Item ID: D3646-1

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Cust Item ID:

Required Date: 03/08/2009 Req'd Qty: 6.00



Customer:

Reference:

Run Start



Approvals: Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

130

Black Sandtex(Ref:4.3.5.7) per QSI005 4.3

0.00



Powdercoat

Memo

0.00

Powder Coating

START TIME: 2:00pm  
2:30pm FINISH TIME:

OVEN TEMPERATURE: 320°F

M109091 9/1 09-07-01 (X6)

140

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

BR 09-07-01 (6)

150

Identify as per dwg & Stock Location: 229

0.00



Packaging

Memo

0.00

Packaging

9/1/2 6X SP

# Work Order ID 47718

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Page 3

Item ID: D3646-1

Accept



Setup Start



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Stop



Item Name: Arm

Start Date: 15/07/2009 Start Qty: 6.00



Cust Item ID:

Required Date: 03/08/2009 Req'd Qty: 6.00



Customer:

Reference:

Run Start



Approvals: Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

09/07/07

HJ

mf  
09-07-08

# Picklist Print

June 26, 2009 4:20:08 PM

Page 1

Work Order ID: 47718

Parent Item: D3646-1RevA

Parent Item Name: Arm


Comments:


Start Date: 15/07/2009

Required Date: 03/08/2009

Start Qty: 6.00

Required Qty: 6.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M304TR0.500W.035		Purchased	No			100	f	113.9814	12.5053			
												
304 RD Tube .500 x .035W												

 M111097  
m-h 09/07/01

Date: Monday, 04/05/2009 1:47:11 PM  
User: Linda Lacelle

# Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: ARM
Job Number	: 47718		
Estimate Number	: 12973		
P.O. Number	:	Part Number	: D36461
This Issue	: 04/05/2009 S.O. No. :	Drawing Number	: D3646 REV.A
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: / / Type : SMALL /MED FAB	Drawing Revision	: A
Previous Run	: 43317	Material	:
Written By	:	Due Date	: 10/05/2009 Qty: 6 Um: Each
Checked & Approved By	: <u>JLM 09.05.09</u>		
Comment	: Est Rev. A new issue 07.07.25 EC verified by:JLM		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	M304TR0500W035	304 RD Tube .500 x .035W
-----	----------------	--------------------------



Comment: Qty.: 2.0790 f(s)/Unit Total : 12.4740 f(s)  
Material: 304/316 Seamless SS tubing, 1/2" O.D. x .035" wall(M304TR0.500W.035)

Batch: M 111097 M-L 09/07/01

2.0	BRAKE NC	NC BRAKE
-----	----------	----------



Comment: NC BRAKE

1-Punch to length as per Dwg D3646 & template DT8958

M-L 09/07/01

3.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
-----	-------------	-------------------------------



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Deburr

M-L 09/07/01

4.0	QC5	INSPECT WORK TO CURRENT STEP
-----	-----	------------------------------



Comment: INSPECT WORK TO CURRENT STEP

5.0	POWDER COATING	POWDER COATING
-----	----------------	----------------



Comment: POWDER COATING  
Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3

START TIME: \_\_\_\_\_  
OVEN TEMPERATURE: \_\_\_\_\_

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Monday, 04/05/2009 1:47:11 PM  
User: Linda Lacelle

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: ARM

Job Number: 47718

Part Number: D36461

Job Number:



Seq. #:

Machine Or Operation:

Description :

FINISH TIME: \_\_\_\_\_

6.0 ✓

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

7.0 ✓

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

8.0 ✓

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion ✓



**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

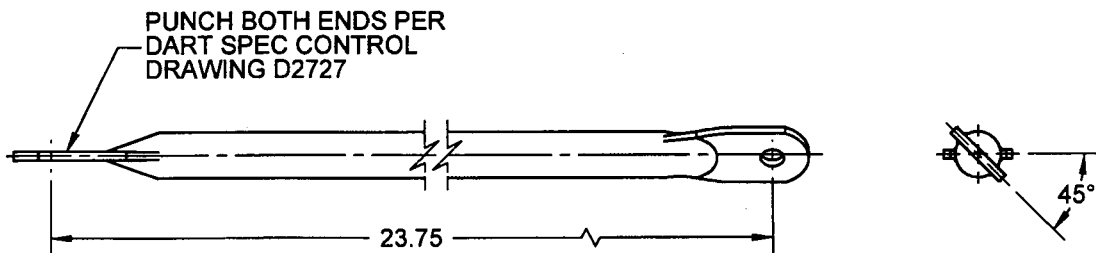
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



**DART**

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DATE 07.06.06	TITLE ARM		SCALE 1:2
REV A	DATE 07.06.06	DESCRIPTION NEW ISSUE	

**RELEASED**07.07.11 *[Signature]***D3646-1 ARM****NOTES:**

- 1) MAKE PER TEMPLATE DT8958
- 2) MATERIAL: AISI 304/316 STAINLESS STEEL SEAMLESS ROUND TUBING  
(REF. DART SPEC. M304TR0.500W.035)
- 3) FINISH: POWDER COAT BLACK SANDTEX (4.3.5.7) PER DART QSI 005413
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX

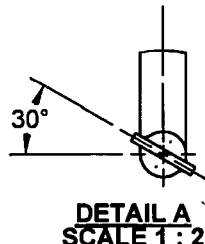
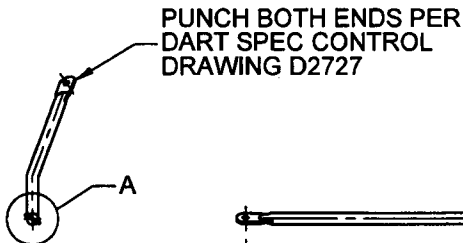
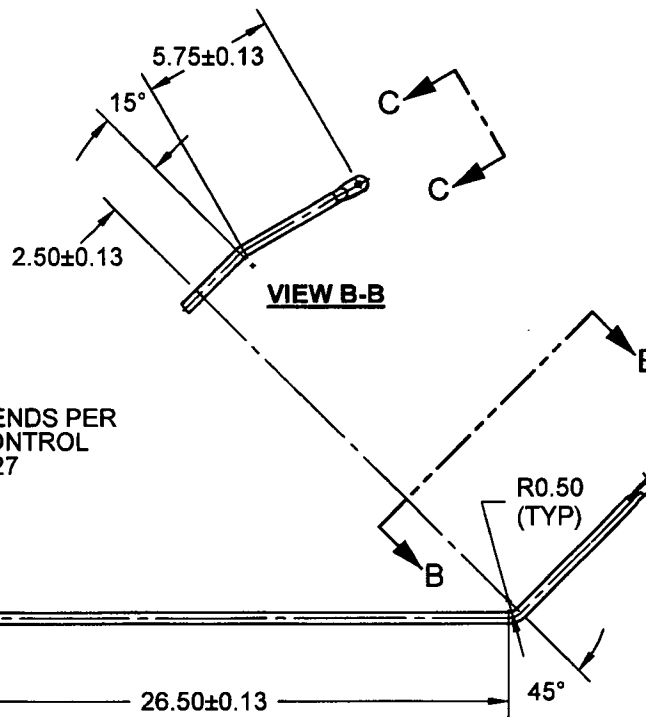
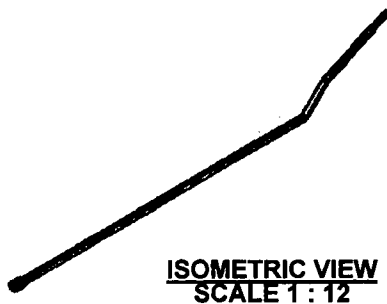
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WITHOUT NOTICE  
WORK ORDER  
NO. 47718

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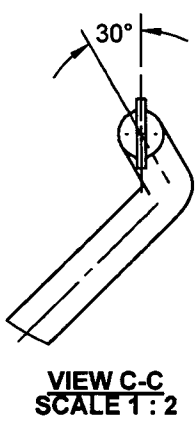
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DATE 07.06.06		TITLE ARM	SCALE 1:8



**RELEASED**  
07.07.11



**D3646-3 ARM**

- NOTES:**
- 1) MAKE PER TEMPLATE DT8959
  - 2) MATERIAL: AISI 304/316 STAINLESS STEEL SEAMLESS ROUND TUBING (REF. DART SPEC. M304TR0.500W.035)
  - 3) FINISH: POWDER COAT BLACK SANDTEX (4.3.5.7) PER DART QSI 005 4.3
  - 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
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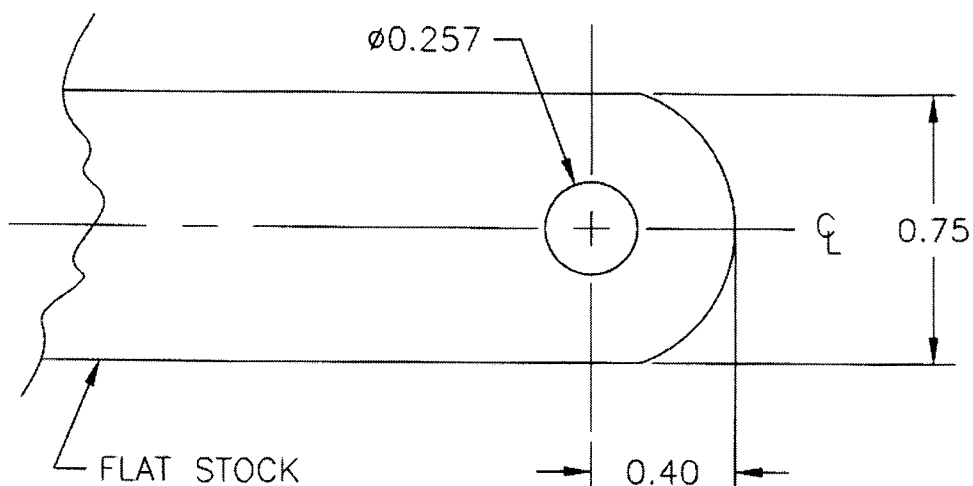
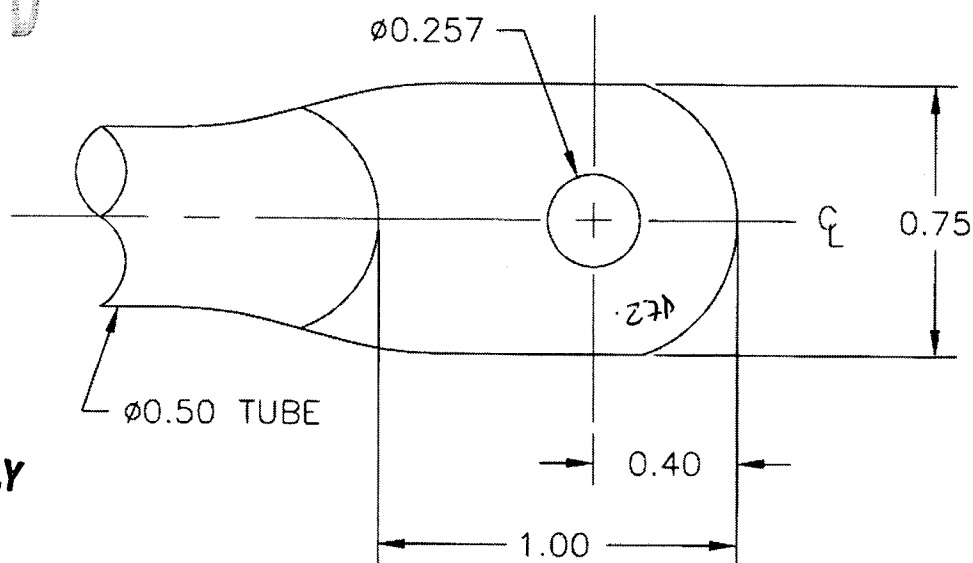


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CHECKED <i>DM</i>	APPROVED <i>KA</i>	DRAWING NO. D2727	REV. A SHEET 1 OF 1
DATE 97.11.24		TITLE PUNCH DT8012 SPEC CONTROL	SCALE 2:1
A	97.11.24	NEW ISSUE	
A1	<i>HCP</i> 01.12.20	ADD TOLERANCE NOTE	

## SPECIFICATION CONTROL DRAWING FOR PUNCH DT8012

RELEASED  
11/98/03/06 KE

REFERENCE ONLY



NOTE: TOLERANCES ARE PER DART QSI DIB UNLESS OTHERWISE NOTED.

